

Work Order ID 137260-1

137260

Page 1

Thursday, September 24, 2015 1:28:39 PM

Item ID: D4149-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: A Stop *NS2*
 Item Name: Aft X-Tube Lug Ass'y
 Start Date: 9/23/15 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 9/23/15 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: SW Date: 150929 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4149	C

100		0.00							
100									
Small Fab	Memo	0.02							
Small Fab	1- Assemble as per dwg								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	Identify as per dwg & Stock Location: St 539	0.00							
120									
Packaging	Memo	0.00							
Packaging									

DAS
36
9-89

DAS
38
9-89

DEC 01 2015

DEC 01 2015

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137260

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Item ID: D4149-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft X-Tube Lug Ass'Y

Start Date: 9/23/15 Start Qty: 6.00

6

Cust Item ID:

Required Date: 9/23/15 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.01

Quality Control

MCJ DEC 01 2015

MCJ DEC 01 2015

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Work Order ID: 137260

137260

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM
11.03.03 as per revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased		No		100	Each	928.0000	4	12			
MS21043-3									**			15/09/29	DAS 36 9-89
Nut													
				<u>Location</u>				<u>Loc Qty</u>					<u>Loc Code</u>
				FG				80					
				103691				80					
				FP001				11					
				m130673				11					
				GA				159					
				m130673				15					
				m131677				144		12			
				ST304				641					
				m131340				199					
				m133031				442					
				ST308				37					
				m132551				37					

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Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 6.00

Required Qty: 6.00

MS21043-4

Purchased

No

100

Each

935.0000

1

18

MS21043-4

Nut

**

15/09/29

DAS
36
9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

119

m128798

119

ST273A

300

m132803

300

ST304

476

m128818

39

m131697

9

m132382

4

m133031

274

m133134

150

D3910-1

Manufactured

No

100

Each

14.0000

1

6

D3910-1

Crosstube Lug

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST523

14

133421

14

D4091-1

Manufactured

No

100

Each

35.0000

1

6

D4091-1

Mounting Lug

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST525

35

133927

35

SEP 29 2015

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Work Order ID: 137260

137260

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'y

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 6.00

Required Qty: 6.00

D4149-1

Manufactured No

100

Each

12.0000

2

12

D4149-1

Crosstube Lug Plate, Aft

**

AS

27

9-89

Location

Loc Qty

Loc Code

ST094

12

125697

1

135542

11

D4149-3

Manufactured No

100

Each

12.0000

1

6

D4149-3

Spacer

**

AS

27

9-89

Location

Loc Qty

Loc Code

ST094

12

135510

12

D4149-5

Manufactured No

100

Each

8.0000

1

6

D4149-5

Eyebolt Stud

**

AS

27

9-89

Location

Loc Qty

Loc Code

ST103a

8

135430

8

AN3C12A

Purchased No

100

Each

106.0000

2

12

AN3C12A

Bolt

**

AS

27

9-89

Location

Loc Qty

Loc Code

GA

71

M128727

71

ST349

35

M128727

35

SEP 29 2015

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Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'y

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 6.00

Required Qty: 6.00

AN4C13A Purchased No

100 Each 96.0000 3 18

AN4C13A

BOLT

**

DAS
27
9-89

Location	Loc Qty	Loc Code
ST312A	92	
m133011	42	
m133234	50	
ST344	4	
m132767	4	

18 17
1

SEP 29 2015

MS20615-4M18 Purchased No

100 Each 212.0000 3 18

MS20615-4M18

Rivet

**

DAS
36
9-89

Location	Loc Qty	Loc Code
GA	212	
m123810	212	

18
24

15/09/29
15/10/05

NAS1149C0332R Purchased No

100 Each 2,582.000 4 24

NAS1149C0332R

WASHER

**

DAS
36
9-89

Location	Loc Qty	Loc Code
FP001	2380	
m130325	1302	
m132930	1078	
GA	127	
m131618	127	
ST271	75	
m129390	75	

24

M133284
24x

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Work Order ID: 137260

137260

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'y

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 6.00

Required Qty: 6.00

NAS1149C0432R

Purchased

No

100

Each

1,285.000

6

36

NAS1149C0432R

**

BAS

WASHER

27

8-89

SEP 29 2015

Location

Loc Qty

Loc Code

GA

1274

m125807

428

m131467

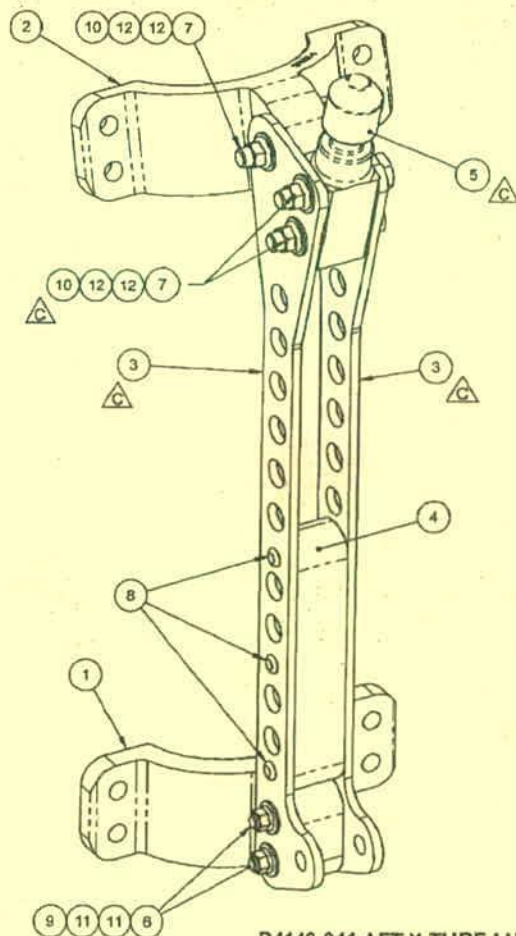
846

ST271

11

m131452

11



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

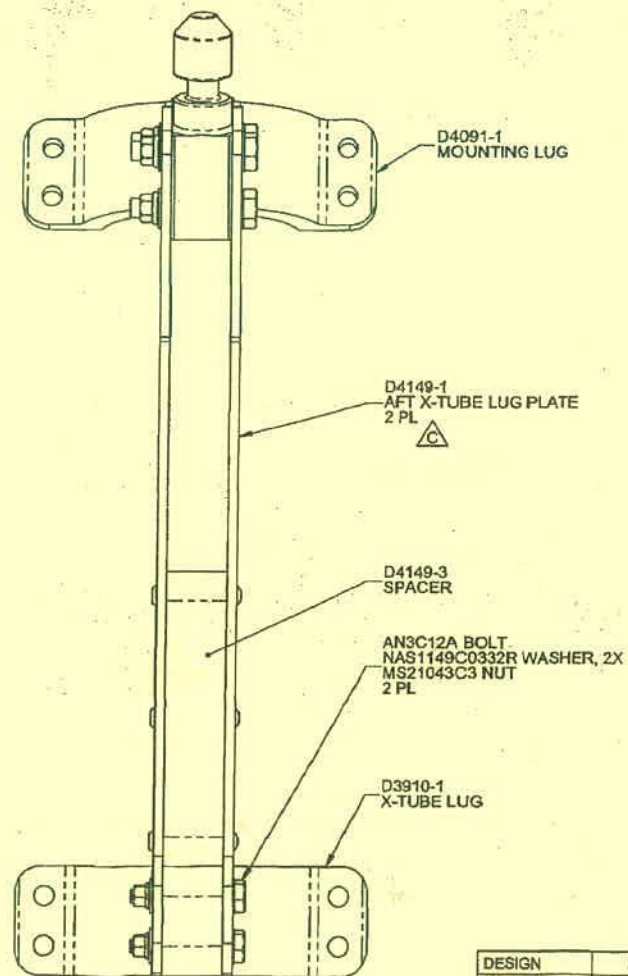
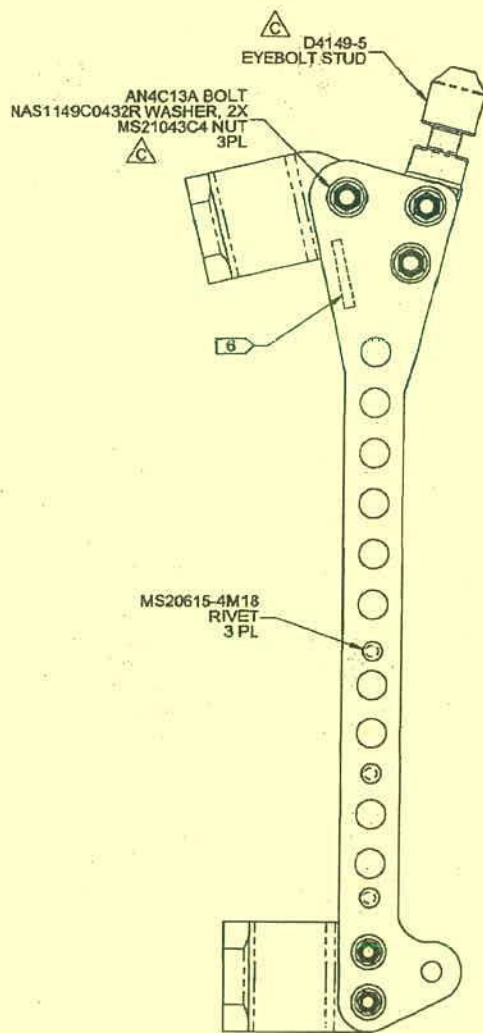
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

20150929

54 137260

RELEASED
2011-02-20

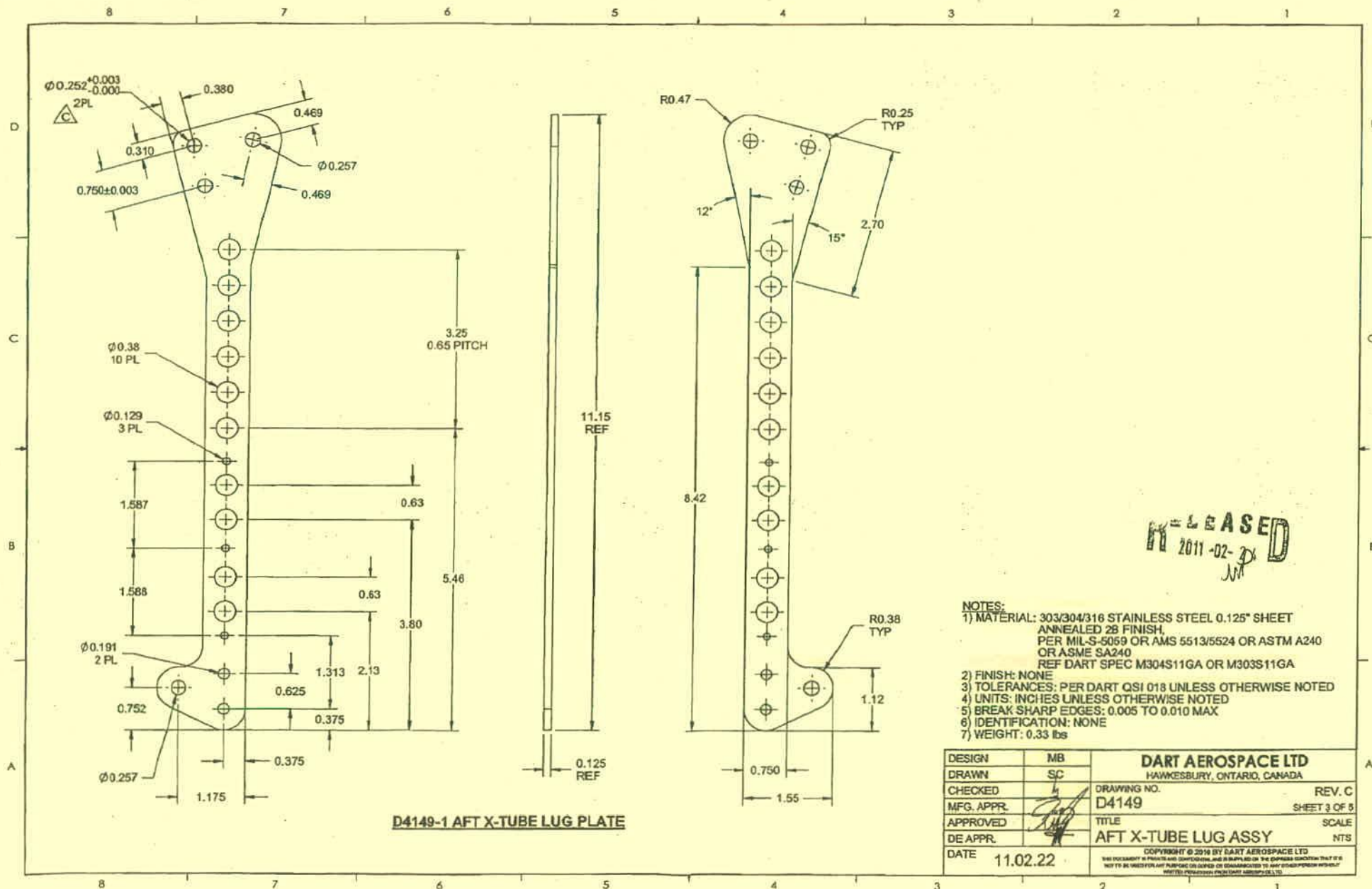
C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.252" (C9-6); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN3C12A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (2N D3-1 & B7-2); ADDED D4149-5 (BHT 5); D4149-5 WAS D3905-5 (2N D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (2N D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.125 3 PL (2N D5-3); REASON: SEE TR-0350-807-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.19
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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D4149-041 AFT X-TUBE LUG ASSY

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2011-02-24
MP

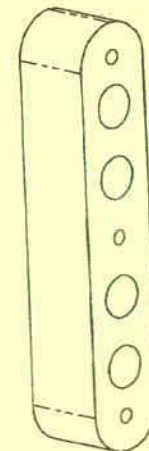
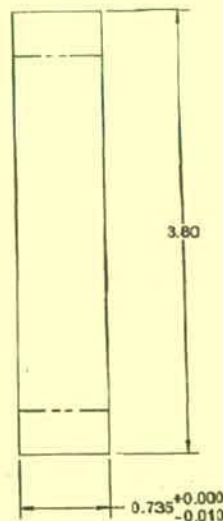
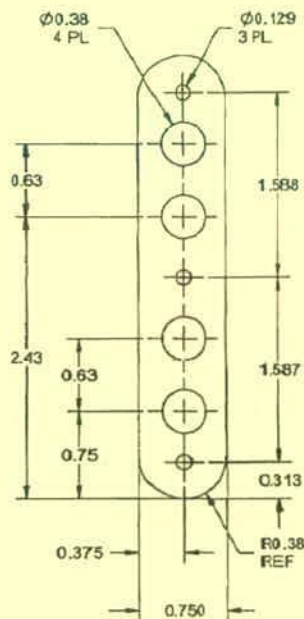
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DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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RELEASED
2011-02-20

- NOTES:
 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET
 ANNEALED 2B FINISH,
 PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240
 OR ASME SA240
 REF DART SPEC M304S11GA OR M303S11GA
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.33 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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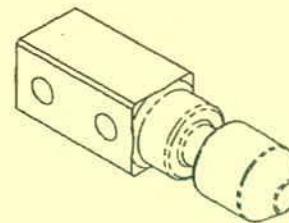
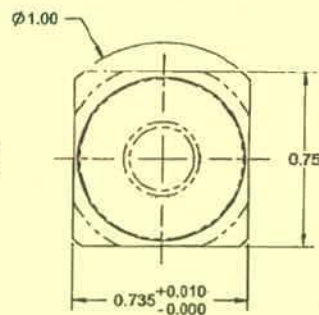
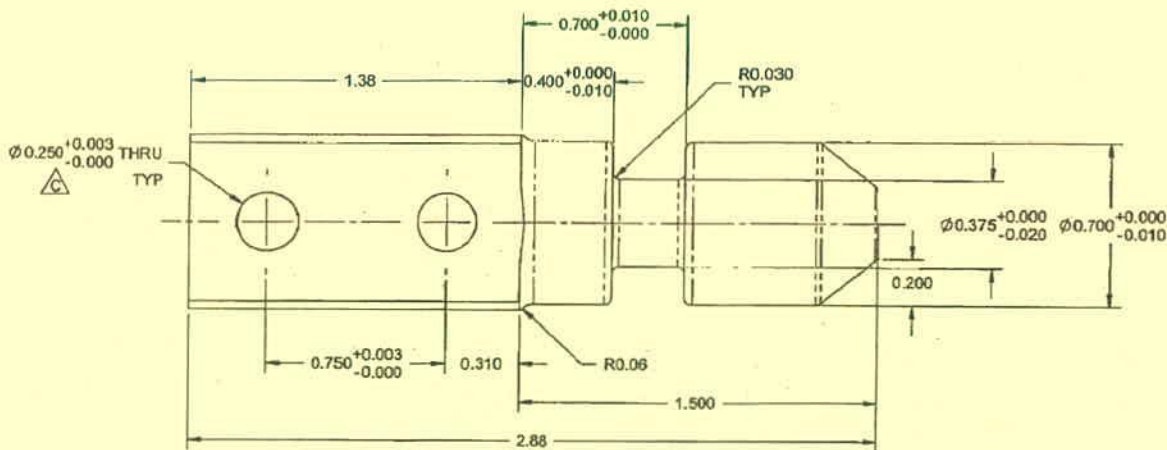
D4149-3 SPACER

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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D4149-5 EYEBOLT STUD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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